



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3307-00-05
Job Sheet 173895



Part No: RBE350A93-3307-00-05

Job Qty: 6 ea

Part Name: Hex Head Cap Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/8/18

Job Tracking No:

Due Date: 4/14/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3307-00 Rev 2A IPP Rev A 18.01.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/14/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	6 pcs		4/14/18	0.00	1.20	MORI SL-154		
120	QC	6 pcs		4/14/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs		4/14/18	0.00	0.00	QC8 Machining-4		
150	Outsource	6 pcs		4/14/18	0.00	0.00	Outsource12		
160	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging2		
170	QC	6 pcs		4/14/18	0.00	0.00	QC6		
180	Packaging	6 pcs		4/14/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea		4/14/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB793 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - -Issue P/O to Groupe Altech; PO 040147 -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92620A750	Hex Head Cap Screw 1/2-20 UNF x 3	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	92620A750	6	10	0

Part Specifications

Specifications could not be found



Container No: S078671



Part: RBE350A93-3307-00-05

Job No: 173895

Serial No/Batch: S078671

Revision: 2A

Inspector:

Exp Date: 06/06/2018

Instructions:

Date: 06/06/18

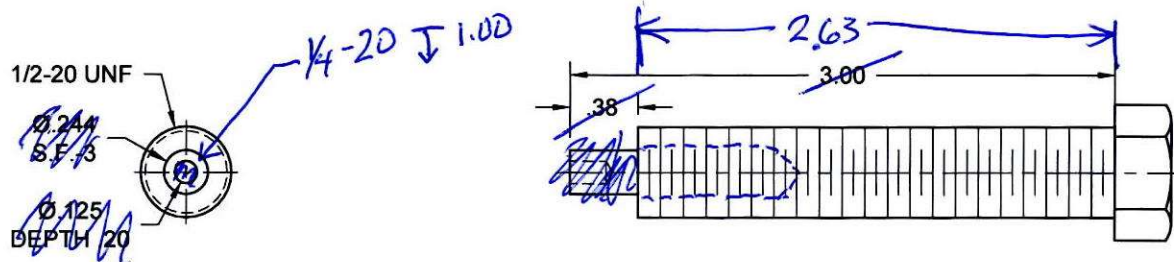
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

lex 3/8/18 8:01 AM Dart.lajeunesse.marie

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D WASHER TO P/N -03 & S.F. TO 5, CH'D ALL THREAD TO HEX HEAD CAP SCREW P/N -05 & S.F. TO 3 PER D.W., DELETED -03 WELDMENT.	11/17/09	RJC	RW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173 895
20180501
2



(-05)

HEX HEAD CAP SCREW

PTO for
derivation

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00-05	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D. Med</i>
FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT FINISH SPEC BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350/355
SCALE NTS	DATE 9/28/09 SHEET 4 of 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>173895</u> Part No. <u>RBE350A93-3307-00</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval March 23, 2018																																																																									
Description Work Order Deviation				Disposition		Completed By																																																																									
As an alternative to expanding the end of the -05 Hex Head Cap Screw to secure the -03 Washer a countersunk screw can be used to secure the -03 Washer. Cut -05 Hex Head Cap Screw 2.63" long and tap 1/4"-20 hole 1.0" deep (on threaded end). Drill 0.25" hole through center of -03 Washer and CSK 0.55" x 82 deg, mfg from 303/304/316 SS, no black oxide required. Apply Loctite 262/263 to McMaster 91253A540 Screw or equivalent and assemble -03 and -05 together. (washer must rotate free),				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.		Lead hand / Supervisor Approval Verification																																																																									
						QC / QA Coordinator Approval																																																																									
Root Cause				FAULT CATEGORY																																																																											
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040147**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040147
PO Date: 6/8/18
Due Date: 6/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173895	RBE350A93-3307-00-05	Hex Head Cap Screw -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	6/13/18	6 pcs	0 pcs	6 pcs	\$18.57142860/pcs	\$111.43
2	173935	RBE703A95-0508-00-1	Quill -Issue P/O to GROUPE ALTECH: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0508-00 Rev 5C	Firmed	6/13/18	12 pcs	0 pcs	12 pcs	\$3.52941176/pcs	\$42.35
3	173880	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to Groupe Altech: PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/13/18	10 pcs	0 pcs	10 pcs	\$3.52941176/pcs	\$35.29

JAB
38
9-88

mt. 18.06.19

12x

At 18/06/15

10x

At 18/06/15

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	176995	RB877406-5-1	Shaft -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	6/13/18	8 pcs	0 pcs	8 pcs	\$8.57142857/pcs	\$68.57
5	173936	RBE703A95-0520-01-1	Quill -Issue P/O to Groupe Altech : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	6/13/18	12 pcs ✓ 12x	0 pcs	12 pcs	\$3.52941176/pcs At 18/06/15	\$42.35
Grand Total:										\$300.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retension of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/11/18 12:45 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(010169-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010169- 2

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
15-Jun-2018		Aman		40147				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3307-00-05 Rev.	RBE350A93-3307-00-05 BLACK OXIDE FINISH MIL-C-13964 CLASS 1 MIL-C-16173 GRADE 4	OXIDE-BLACK CH	6	6	0	0	0
4	RB877406-5-1 Rev.	RB877406-5-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] BLACK OXIDE FINISH, MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C23411A OR MIL-PRF-81309 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	8	8	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.